

5/29

SPLIT

DART AEROSPACE LTD		Work Order:	23797B
Description: Lug		Part Number:	D3338-1
Dwg: D3338 Rev. A		Qty:	to 20
Page 1 of 1			

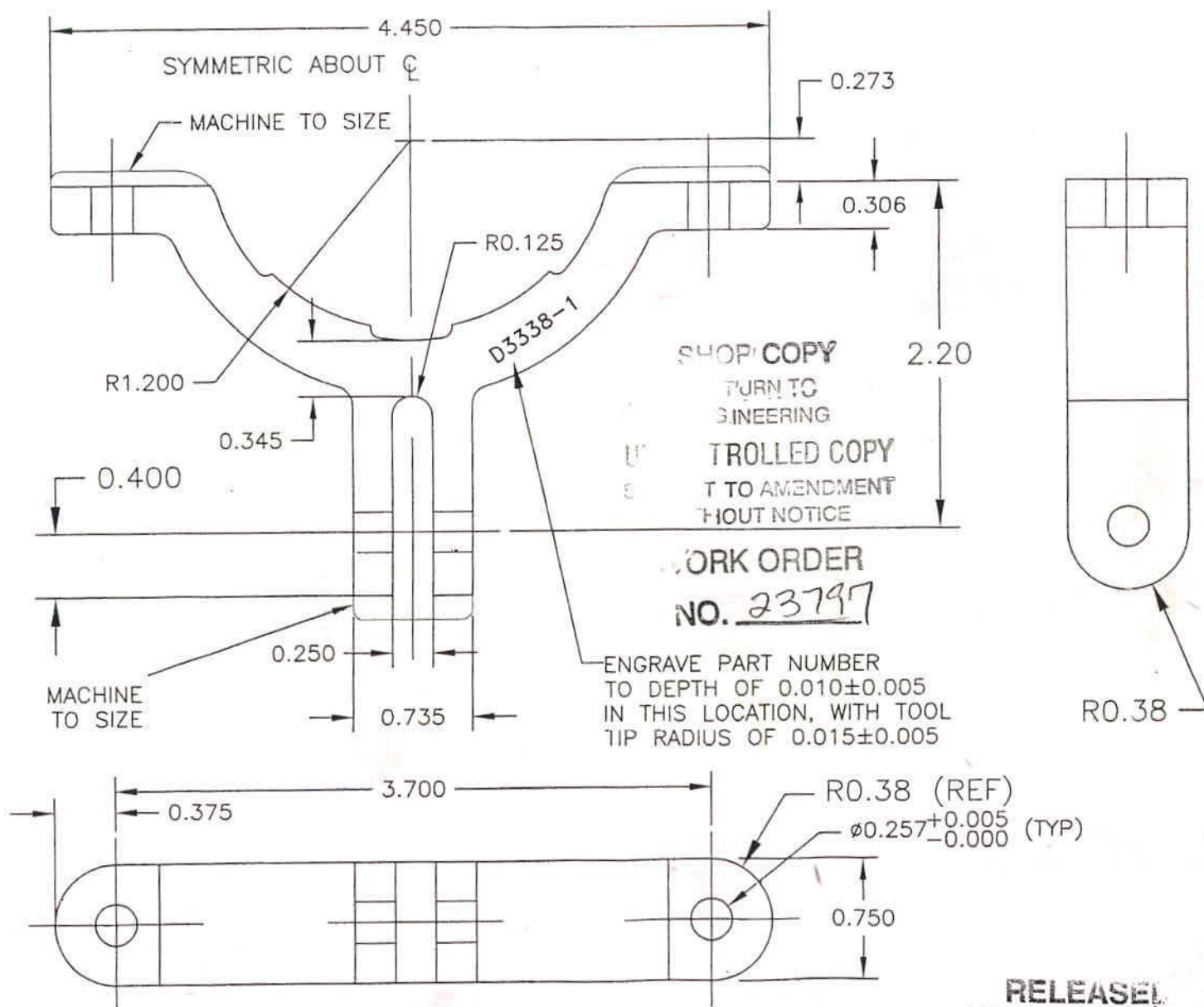
Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HJ	05.07.13	to 20
2	MV	Cut D2423 extrusion to 0.82" Identify for D3338-1	PC	05.08.10	20
3	MV P6	Machine D3338-1 as per Folio FA506 and Dwg D3338 Check for extrusion defects while loading into the machine Identify as D3338-1	U	05.07.13	10 20
4	QC2 P6	Inspect parts as they come off the CNC machine Receive & inspect for transit damage	CH	05.08.12	24
5	QC6	Second check inspect level 5	2	05.08.24	24
6	MV	Tumble and Deburr if applicable	DL	05.12.15	24
7	QC5	Inspect work to Step 6	2	05.12.16	24
8	FP	Acid etch and Alodine as per QSI 005 4.1	SAD	05/12/28	24
9	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	FL	06.02.07	24
10	QC3	Inspect Powder Coat	ml	06.02.07	24
11	ST	Identify and Stock	PJ	06/2/8	24
12	AC	Cost / part:	U	06.02.08	24
13	DC	Close W/O Inspect Level 21	G	06/02/08	24

Rev	Date	Change	Revised By	Approved
A	05.02.09	New issue	KJ/JLM	

RELEASED
05.02.15



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3338	REV. A SHEET 1 OF 1
DATE 04.11.03	TITLE MOUNTING LUG		SCALE 1:1
A	04.11.03	NEW ISSUE	



D3338-1 NOTES

- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

04.12.16

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:36 am

Work Order No : 0023797
Project Name : D3338-1
Project For : WK529
Work Order Type : Main
Main WO Number :
House Part Number : D3338-1
Description : Mounting Lug
Manufactured : Yes
Amount Req'd : 10
Amount Done : 2
Start Date : 07-13-05
Est Finish Date : 07-22-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%

Part/All Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	442.82	100.00	37.22	405.60
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	1.76	100.00		
Production Cost :	0.00	34.92	100.00	11.55	23.37
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	477.74	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	477.74			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.88
Profits/(Loss) :	0.00	(-477.74)

*Mis o/B
w
H.B*

Date: Monday, 14/11/2005 8:31:20 AM
 User: Alba Panzuto

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 23797		
Estimate Number	: 10451		
P.O. Number	:	Part Number	: D33381
This Issue	: 14/11/2005 S.O. No. :	Drawing Number	: D3338 REV. A
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 30/11/2005 Qty: 8 Um: Each
Checked & Approved By	:		
Comment	: Est:A 05.02.09 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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2.0	BAND SAW	BAND SAW
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Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
 BAND SAW
 Cut D2423 Extrusion: 0.82" Long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
 HAAS CNC VERTICAL MACHINING #1
 1- Check for extrusion defects while loading into the machine
 2- Machine as per Folio FA506 and Dwg D3338
 3- Tumble and Deburr
 Identify as D3338-1

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
 INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
 SECOND CHECK

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
 HAND FINISHING RESOURCE #1
 Acid etch and Alodine as per QSI 005 4.1

Date: Monday, 14/11/2005 8:31:20 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 23797

Part Number: D33381

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

DC

DOCUMENT CONTROL



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

DOCUMENT CONTROL

Inspection Level 21

Job Completion

